

Work Order ID 117149

117149

Page 1

June-09-14 11:33:51 AM

Item ID: D3363-1 Accept *N9000040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Console
 Start Date: 4/23/14 Start Qty: 16.00 *16* Cust Item ID:
 Required Date: 4/23/14 Req'd Qty: 16.00 *16* Customer:
 Reference:

Approvals: Process Plan: W Date: Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3363	Rev C

105		0.00							
105									
Purchasing	Memo	0.00							
Purchasing	ISSUE PO 24574								
	CUT PER DRWG D3363 REV.C								

CL 14/06/12 16

115	Receive & Inspect for Damage & Mat'l Certs	0.00							
115									
Packaging	Memo	0.00							
Packaging									

17/12/11 (16)

125	QC6- Inspect dimensions to drawing	0.00							
125									
QC	Memo	0.00							
Quality Control									

(16)

DAS 38
 DAS 9 9-89 14-8-22
 9-89

Work Order ID 117149

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Item ID: D3363-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Console
 Start Date: 4/23/14 Start Qty: 16.00 ***16*** Cust Item ID:
 Required Date: 4/23/14 Req'd Qty: 16.00 ***16*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool # DAS 30 9-89	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Brake NC Brake NC	Bend as per dwg NC BRAKE Memo Debur Form as per Dwg D3363 ***REMOVE ALL BENDING MARKS AFTER BENDING***	0.00 0.00				<u>16</u>			<u>14609/24</u>
140 *140* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				<u>16</u>			DAS 38 9-89 <u>145-26</u>
150 *150* Large Fab Large Fab	Weld per dwg A/R Aluminum rod Batch: <u>128316</u> Large Fab Memo 1-Weld using DT8790 as per Dwg D3363 and QSI 004 2- Grind weld flush as per dwg	0.00 0.00				<u>16</u>			<u>14-10-15</u> <u>JBL</u>

Work Order ID 117149

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Item ID: D3363-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Console

Start Date: 4/23/14

Start Qty: 16.00

16

Cust Item ID:

Required Date: 4/23/14

Req'd Qty: 16.00

16

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC9- Inspect visual per QSI004- Fusion Welds

0.00

160

QC

Memo

0.00

Quality Control

16

OCT 17 2014

DAS
24
9-89

170

QC5- Inspect part completeness to step on W/O

0.00

170

QC

Memo

0.00

Quality Control

16

OCT 17 2014

DAS
24
9-89

180

Identify as per dwg & Stock Location

0.00

180

Packaging

Memo

0.00

Packaging

G-A
u/o 125666

16x

15/02/24

DAS
36
9-89

171

~~Hand Finish Chemical conversion coat~~

15.02.24

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Item ID: D3363-1 Accept *N900040100* Setup Start *NS1*
Revision ID: Stop *NS2*
Item Name: Console
Start Date: 4/23/14 Start Qty: 16.00 *16* Cust Item ID:
Required Date: 4/23/14 Req'd Qty: 16.00 *16* Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	QC21- Final Inspection - Work Order Release	0.00							
190									
QC	Memo	0.00							
Quality Control									

15/2/25

15-2-25

Picklist Print

June-09-14 11:33:50 AM

Page 1

Work Order ID: 117149

117149

Parent Item: D3363-1

D3363-1

Parent Item Name: Console

Start Date: 4/23/14

Required Date: 4/23/14

Start Qty: 16.00

Required Qty: 16.00

Comments: IPP: B05.09.09 Remove c'sink rivet holes and add welding step KJ/JLM
IPP: C 06.11.15 waterjet EC
IPP Rev:D 08-07-14 add comment in QC5 inspection DD verified by:ec
IPP REV:E 14.01.15 removed aloddine & add it to D212-722-011 DD
verf:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M6061T6S.063

Purchased

No

100

sf

503.0880

2.3

39

M6061T6S 063

**

CL 14/06/127

6061-T6 .063 Sheet

Location

Loc Qty

Loc Code

MAT021

503.088

M124446

3.7

M126075

4.5

M127006

9

M127420

117.12

M128054

84.768

M128941

284

M129637

39

DART AEROSPACE LTD		Work Order:	117149
Description: Console		Part Number:	D3363-1
Inspection Dwg: D3363 Rev: C		Page 1 of 2	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.098	+0.004/-0.001	0.099"	-		✓	Jkmo1
Ø0.128	+0.005/-0.001	0.129"	-		✓	
Ø0.469	+0.006/-0.001	0.470"	-		✓	
14.41	+/-0.030	14.41"	-		T	Jkmo3
14.097	+/-0.010	14.097"	-		T	
12.409	+/-0.010	12.409"	-		T	
11.354	+/-0.010	11.354"	-		✓	Jkmo8
10.706	+/-0.010	10.706"	-		✓	
10.081	+/-0.010	10.081"	-		✓	
4.331	+/-0.010	4.331"	-		✓	
3.706	+/-0.010	3.706"	-		✓	
3.058	+/-0.010	3.058"	-		✓	
2.004	+/-0.010	2.004"	-		✓	
2.366	+/-0.010	2.366"	-		✓	
3.100	+/-0.010	3.100"	-		✓	
5.040	+/-0.010	5.040"	-		✓	
5.415	+/-0.010	5.415"	-		✓	
2.25	+/-0.030	2.25"	-		✓	
19.965	+/-0.010	19.965"	-		T	
20.366	+/-0.010	20.366"	-		T	
21.318	+/-0.010	21.318"	-		T	
22.90	+/-0.030	22.90"	-		T	
0.315	+/-0.010	0.315"	-		✓	
3.706	+/-0.010	3.706"	-		✓	
4.025	+/-0.010	4.025"	-		✓	
7.206	+/-0.010	7.206"	-		✓	
1.75	+/-0.030	1.75"	-		✓	
10.387	+/-0.010	10.387"	-		✓	
19.590	+/-0.010	19.590"	-		T	

DART AEROSPACE LTD		Work Order: 117149
Description: Console		Part Number: D3363-1
Inspection Dwg: D3363	Rev: C	Page 2 of 2

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
18.990	+/-0.010	18.990"	-		T	
1.80	+/-0.030	1.80"	-		V	
6.390	+/-0.010	6.390"	-		V	
5.790	+/-0.010	5.790"	-		V	
4.475	+/-0.010	4.475"	-		V	
4.100	+/-0.010	4.100"	-		V	
2.725	+/-0.010	2.725"	-		V	
2.00	+/-0.030	2.00"	-		V	
6.363	+/-0.010	6.363"	-		V	
10.737	+/-0.010	10.737"	-		V	
11.206	+/-0.010	11.206"	-		V	
3.206	+/-0.010	3.206"	-		V	
3.675	+/-0.010	3.675"	-		V	

Measured by: ^{DAS} 23 9-89	Audited by: ^{DAS} 33 9-89	Prototype Approval: N/A
Date: 14-08-22	Date: 14-8-22	Date: N/A

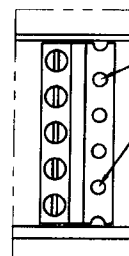
Rev	Date	Change	Revised by	Approved
A	08.02.28	New Issue	KJ/DD	

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD	REV. C
117149	PH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	SHEET 1 OF 3
PH	PH	D3363	
DATE	TITLE	SCALE	
07.01.26	CONSOLE ASSEMBLY	1:5	
A	04.11.29	NEW ISSUE	
B	05.03.28	INCREASE WIDTH BY 0.125	
C	07.01.26	T'DRILL DZUS RAIL, WIDEN BASE CUTOUT	

RELEASED
07.06.04

TRANSFER DRILL #30 FROM D3362-1 DZUS RAIL THROUGH D3363-1 CONSOLE (TYP 4 PLACES) C'SINK (Ø0.225 X 100") FROM TOP SIDE OF CONSOLE



DETAIL C
(SCALE 1:2)

C'SINK THIS SIDE (REF)

117149 MJS
14-04-29

DETAIL C

INSTALL D3361-1 & D3362-1 USING MS20426AD4-6 RIVETS (TYP 9 PLACES)

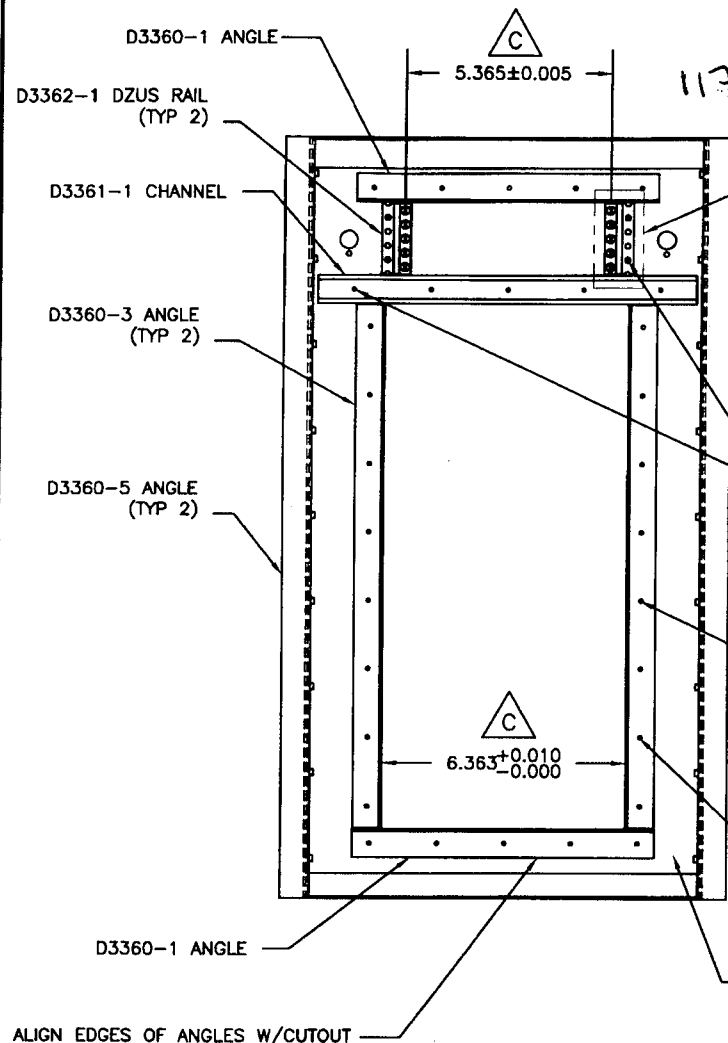
TRANSFER DRILL #30 FROM MATING PARTS THROUGH #40 HOLES IN D3363-1 CONSOLE (TYP 49 PLACES) C'SINK (Ø0.225 X 100") FROM CONSOLE TOP SIDE

INSTALL D3360-1/-3/-5 ANGLES USING MS20426AD4-5 RIVETS (TYP 44 PLACES)

D3363-1 CONSOLE

PARTS LIST FOR D3363-041 CONSOLE ASSEMBLY

QTY	PART NUMBER	DESCRIPTION
1	D3363-041	CONSOLE ASSEMBLY
2	D3360-1	ANGLE
2	D3360-3	ANGLE
2	D3360-5	ANGLE
1	D3361-1	CHANNEL
2	D3362-1	RAIL
1	D3363-1	CONSOLE
44	MS20426AD4-5	RIVET
9	MS20426AD4-6	RIVET



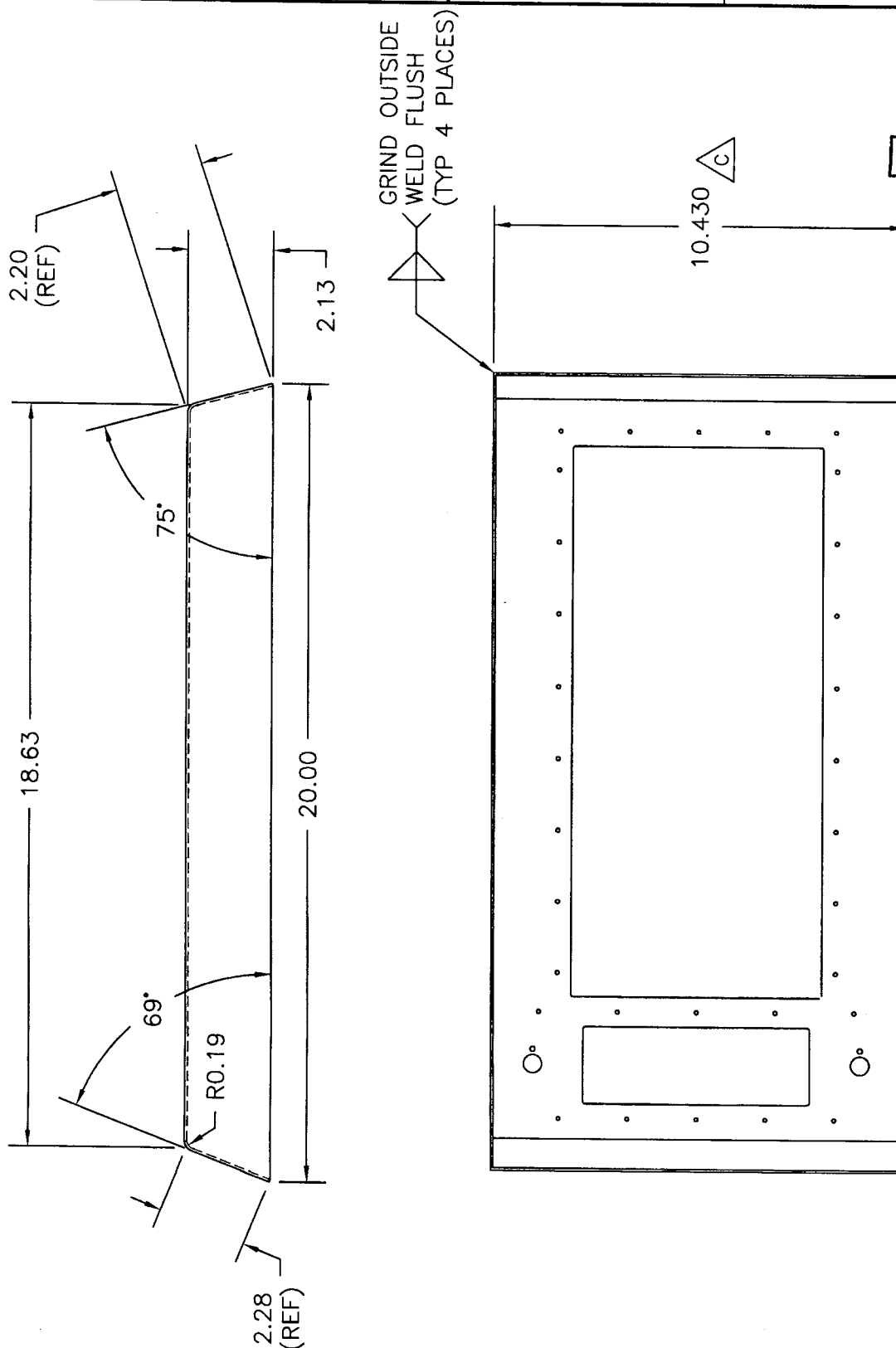
VIEW A-A FROM UNDER CONSOLE ASSEMBLY

D3363-041 CONSOLE ASSEMBLY

- 1) ASSEMBLE IN ACCORDANCE WITH DART QSI 002
- 2) IDENTIFY WITH DART P/N D3363-041 AND B/N BXXXXX USING FINE POINT PERMANENT INK MARKER
- 3) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1



DESIGN <i>RH</i>	DRAWN BY <i>RH</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3363	REV. C SHEET 2 OF 3
DATE 07.01.26	TITLE CONSOLE ASSEMBLY		SCALE 1:4



RELEASED

07.06.04 *[Signature]*

D3363-1 BEND DETAIL

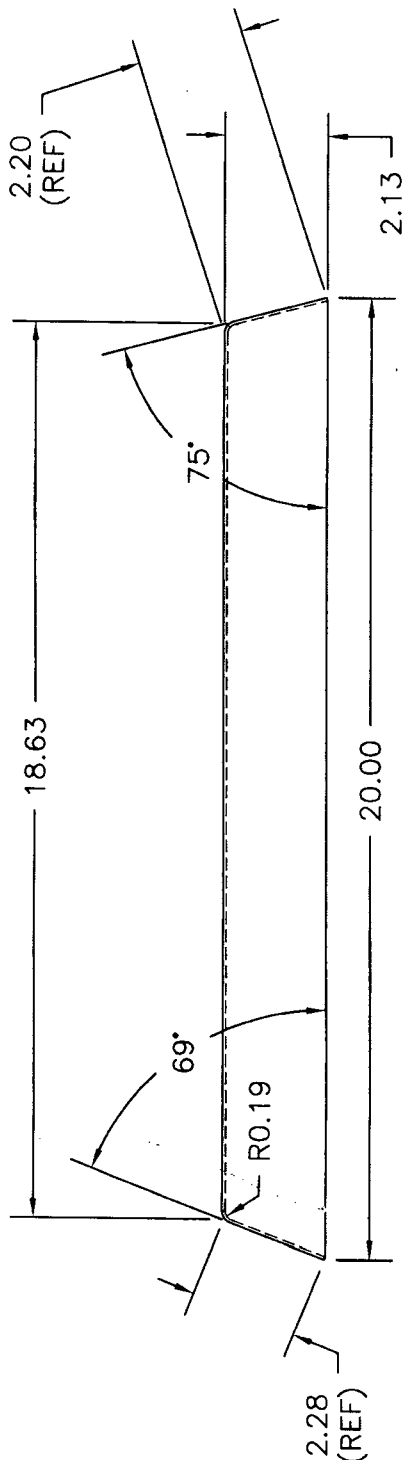
(MAKE FROM D3363-1F FLAT PATTERN)

D3363-1 CONSOLE

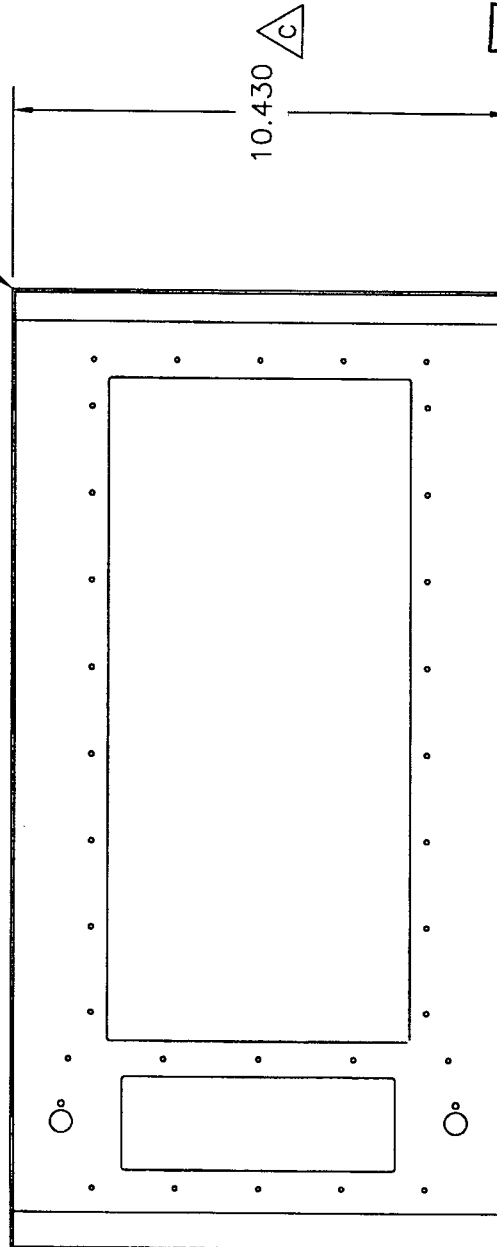
- 1) WELD PER DART QSI 004
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



DESIGN <i>PH</i>	DRAWN BY <i>PH</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>JS</i>	APPROVED <i>JS</i>	DRAWING NO. D3363	REV. C SHEET 2 OF 3
DATE 07.01.26	TITLE CONSOLE ASSEMBLY		SCALE 1:4



GRIND OUTSIDE
WELD FLUSH
(TYP 4 PLACES)



RELEASED

07.06.04 *JS*

D3363-1 BEND DETAIL

(MAKE FROM D3363-1F FLAT PATTERN)

D3363-1 CONSOLE

- 1) WELD PER DART QSI 004
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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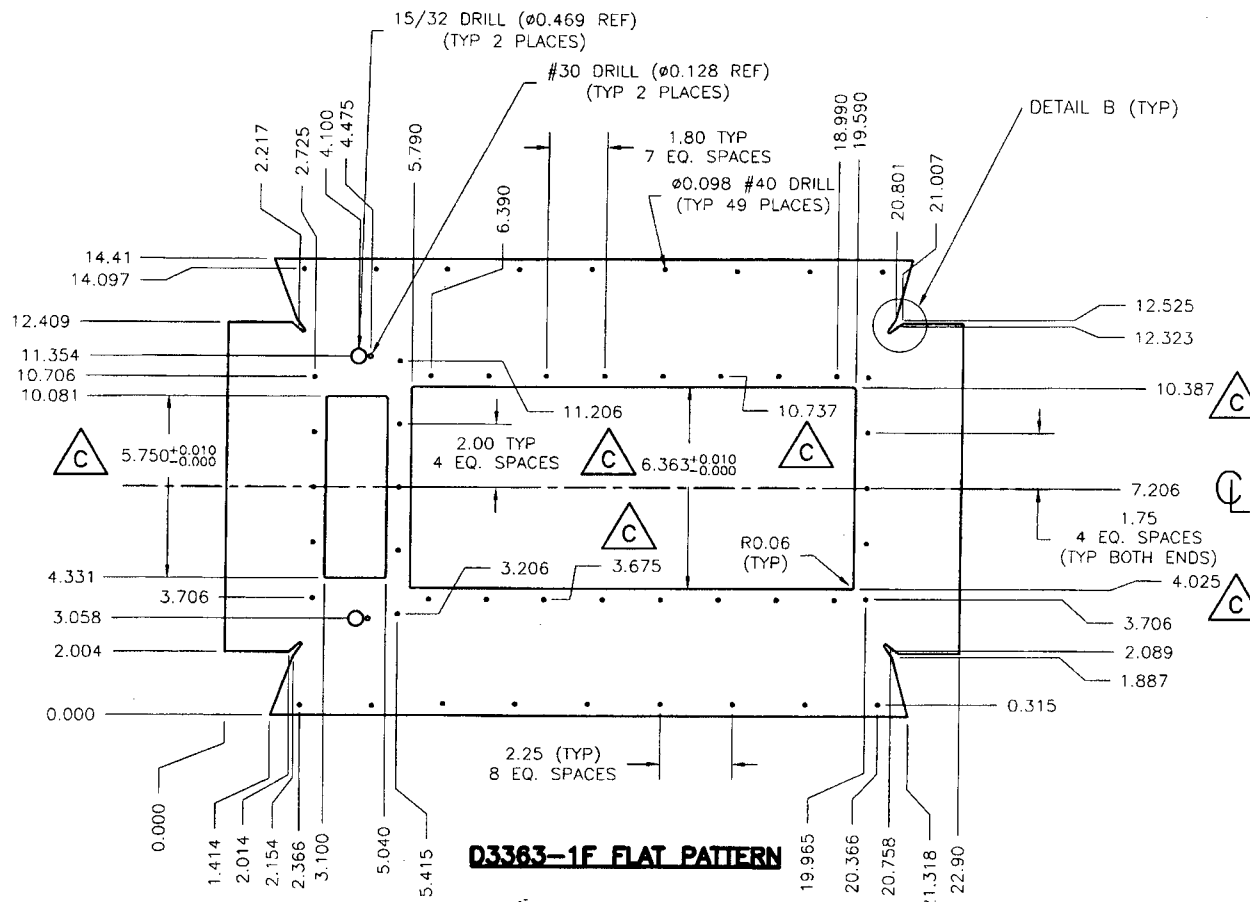
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DART

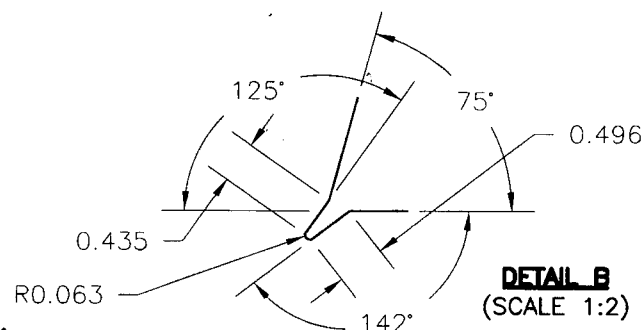
DESIGN	BY	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	3	APPROVED	D3363
DATE	07.01.26	TITLE	CONSOLE ASSEMBLY
		REV. C	SHEET 3 OF 3
		SCALE	1:6

RELEASED

07.06.04



D3363-1F FLAT PATTERN



DETAIL B
(SCALE 1:2)

D3363-1F CONSOLE (FLAT PATTERN)

- 1) MATERIAL: 6061-T6/T651 ALUMINUM 0.063 THICK
PER QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF DART SPEC M6061T6S.063)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) PART IS SYMMETRICAL ABOUT CENTERLINE

T.P.I. INDUSTRIES INC.

148 GOODFELLOW
 DELSON, QUÉBEC J5B 1V4
 CANADA
 Tel: (450) 633-0484
 Fax: (450) 633-0879

Packing Slip

Packing Slip No.: 6192
 Date: 2014-07-10
 Page: 1

Sold to:	Ship to:
Dart Aerospace Michael Grégoire 1270 Aberdeen Hawkesbury, Ontario K6A 1K7 Canada	Dart Aerospace Michael Grégoire 1270 Aberdeen Hawkesbury, Ontario K6A 1K7 Canada
Order No.: 24574	Sold By: JONATHAN LESSARD
Shipped By:	Ship Date: 2014-07-10
Tracking No.:	

Item No.	Unit	Description	Quantity
646.3711	Chaque	646.3711 clip	40
646.3712	Chaque	646.3712 clip	20
646.3712	Chaque	646.3712 clip	40
646.3713	Chaque	646.3713 gusset	40
646.3714	Chaque	646.3714 gusset	40
646.3717	Chaque	646.3717 doubler	30
646.3719	Chaque	646.3719 doubler	20
646.3719	Chaque	646.3719 doubler	40
d2365	Chaque	d2365 wearplate pin	30
d3283-1	Chaque	d3283-1 doubler	40
d3208-3	Chaque	d3208-3 pedal mount angle	20
d3290-1	Chaque	d3290-1 frame	30
d3302-1	Chaque	d3302-1 doubler	10
d3302-3	Chaque	d3302-3 doubler	10
d3363-1	Chaque	d3363-1 console	16
d4072-3	Chaque	d4072-3 airframe hinge backing plate	40
d4073-3	Chaque	d4073-3 door hinge backing plate	50
d4074-5	Chaque	d4074-5 backing plate	40
d4610-5	Chaque	d4610-5 shim	20

Comment: Net / 30 from date of invoice 2% svc. chg. on invoices over 30 days